Work Order ID 72963

Tuesday, August 23, 2011 8:08:29 AM

Item ID: D2327-3 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Spacer Bushing

Start Date: 8/23/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 8/29/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** ✓ **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: D2327 / Rev D									
100	Hardinge CNC LATHE SMALL	0.00							
Hardinge	**Memo**	0.00							
Hardinge CNC Lathe Small	Turn per Folio FA232 and Dwg D2327	Deburr							
			ok 11/08/29			20	ø		
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00							
Quality Control			ok 11/08/29			20	ø		
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00							
Quality Control			SL 11/08/29			20			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 72963

Tuesday, August 23, 2011 8:08:29 AM

Item ID: D2327-3
Revision ID:
Item Name: Spacer Bushing

Start Date: 8/23/2011 **Start Qty:** 20.00
Required Date: 8/29/2011 **Req'd Qty:** 20.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: WA	0.00							
Packaging	**Memo**	0.00							
Packaging	*****STOCK IN BASKET CELL*****								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

SP 11-08-30

11/8/30

MF 11-08-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Tuesday, August 23, 2011 8:08:36 AM

Work Order ID: 72963

Parent Item: D2327-3

Parent Item Name: Spacer Bushing

Start Date: 8/23/2011 **Required Date:** 8/29/2011

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP F[illegible]05.11.02[illegible]Removed 303 SS[illegible]KJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	31.0600	0.1563	3.290526			

304 ROUND BAR 0.375

Location	Loc Qty	Loc Code
MAT029	31.06	
117130	2.46	
118449	28.6	

3.3 ok 11/08/29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	72963
Description: Spacer Bushing	Part Number:	D2327-3
Inspection Dwg: D2327 **Rev:** D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

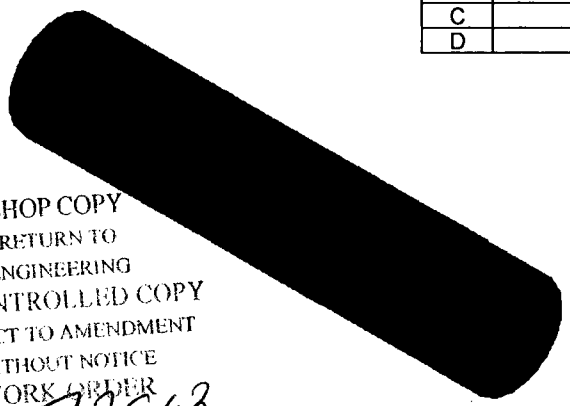
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	Ø.375	—		Vern 11-06	
Ø0.257	+0.005/-0.000	Ø.257	—		"	
1.750	+/-0.010	1.750	—		"	

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/08/29	Date:	11-08-29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	08.01.28	Tolerance revised on Ø0.375	KJ/EC/DD	

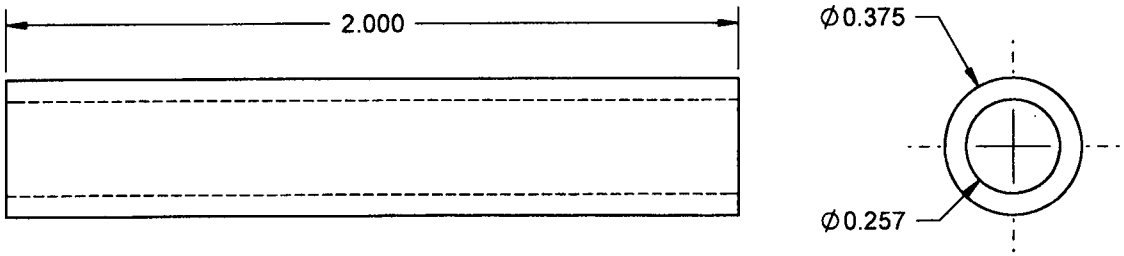
DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. D
LE		D2327 SHEET 1 OF 1
DATE		TITLE SCALE
06.10.12		SPACER BUSHING 2:1

REV	DATE	DESCRIPTION
A	94.12.17	NEW ISSUE
B	95.12.06	LENGTH CHANGE
C	03.05.13	303 SS SPEC ADDED
D	06.10.12	REMOVE 303 SS MATERIAL

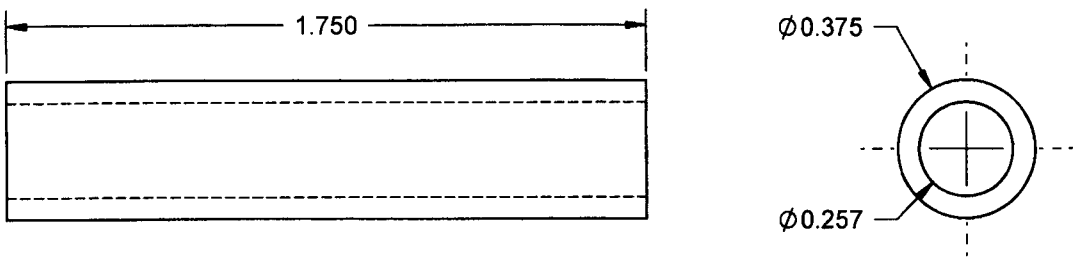


RELEASED
06.11.14

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72943 2011-05-23



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:
1) MATERIAL: AISI 304/316 SS, Ø0.375, 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC M304TR0.375W.065) △D
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS TO 0.010 MAX

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